

(C)

PLOT SCALE:

1=1

DWG. SCALE: 1

A16908

4

3

2

1

D

D

C

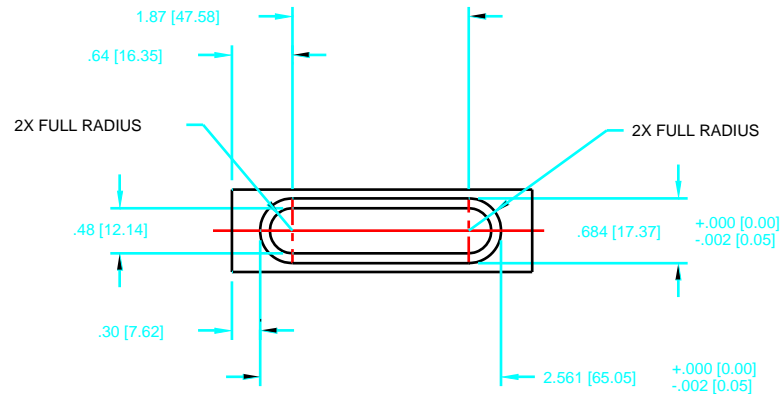
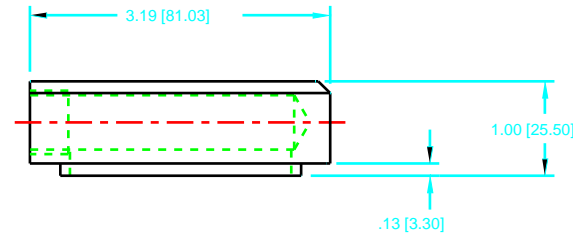
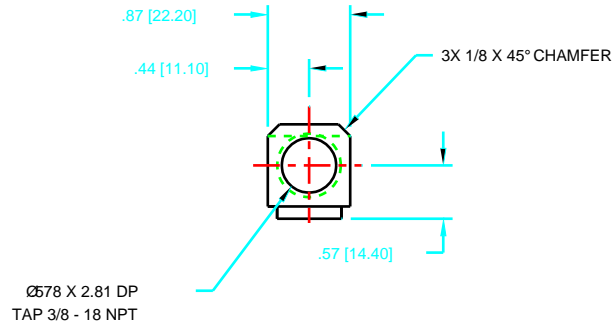
C

B

B

A

A



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

2	REDESIGNED	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS				
ANGULAR				
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A16908		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY MUSCIA	DATE 3/14/94	CHIEF DESIGN ENGINEER D. SHU	DATE 5/7/93	TITLE ADVANCED PHOTON SOURCE
CHECKED BY D. SHU		GP LEADER T.M. KUZAY	DATE 5/7/93	M1 APS I.D. FRONT END
DESIGNER SHU/MUSCIA		PROJECT MGR.		1-ST FIXED MASK
RESPONSIBLE ENGINEER D.SHU	5/7/93	APPROVED/RELEASED		UPPER & LOWER PIPE CONNECTIONS
MATERIAL OFHC COPPER		SCALE 1:1		
		SIZE C		
		DRAWING NUMBER P4102010101-210002-02		
		SHEET 1 of 1		